

Work Order ID 86324

Wednesday, June 27, 2012 10:54:13 AM

Push Now
86324

Page 1

Item ID: D4422-3

Accept

No W
N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Shim

Start Date: 6/27/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 6/27/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan: *mk*Date: *12-06-27* Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4422

A

100

0.00

100

Small Fab

Memo

0.00

Small Fab

Shear as per dwg D4422

*2**φ**FF*
12-06-27

110

QC6- Inspect dimensions to drawing

0.00

110

QC

Memo

0.00

Quality Control

*②**SH*
*12/6/27**115-**PTO*

120

Identify as per dwg & Stock Location: _____

0.00

120

Packaging

Memo

0.00

Packaging

12/6/27

W/O: 86324

Rem CAG

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
12-06-27	115	Needs to add. a/c time. update routing.	JS	12677		h	

Part No: D4422-3 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 86324***86324***

Page 2

Wednesday, June 27, 2012 10:54:13 AM

Item ID: D4422-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Shim

Stop ***NS2***Start Date: 6/27/2012 Start Qty: 2.00 ***2***

Cust Item ID:

Required Date: 6/27/2012 Req'd Qty: 2.00 ***2***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____

Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

130

QC21- Final Inspection - Work Order Release

0.00

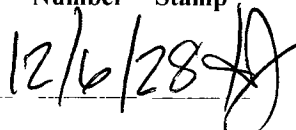
130

QC

Memo

0.00

Quality Control

12/6/28 
WV
12-06-27

Picklist Print

Wednesday, June 27, 2012 10:54:13 AM

Page 1

Work Order ID: 86324

Parent Item: D4422-3

Parent Item Name: Shim

Start Date: 6/27/2012

Required Date: 6/27/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP revA 11.06.30 new issue EC verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6S.063

Purchased

No

sf

514.0868

0.0488632

6061-T6 .063 Sheet

Location

Loc Qty

Loc Code

MAT021

514.0868320

113608

0

116308

5.01556842

117285

67.544

119331

44.2

119802

5.94

120218

17.31

120866

64.8126316

121805

309.264632

0.0488632

2

FF 12-06-27

8 7 6 5 4 3 2 1

D

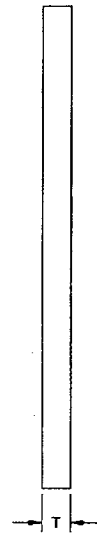
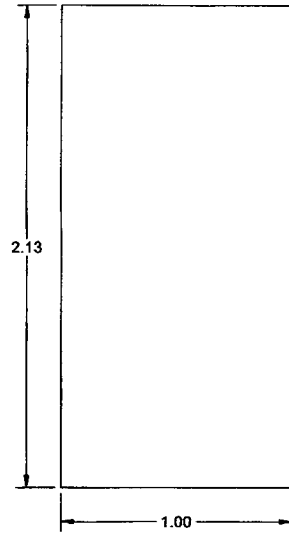
D

C

C

B

B



D4422-X SHIM

P/N	"T" THICKNESS
D4422-1	0.125
D4422-3	0.063

NOTES:

1) MATERIAL:

D4422-1: 6061-T6/T62 ALUMINUM SHEET, 0.125 THICK, PER QQ-A-250/11
OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.125
OR
6061-T6/T651/T6510/T6511/T62, 0.125 X 1.000, PER QQ-A-225/8
OR AMS-QQ-225/8 (OR AMS 4117/4128/4115/4116) OR QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B

D4422-3: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK, PER QQ-A-250/11
OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.063

- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4422-X" AND B/N PER QSI 044 6.1
7) WEIGHT: D4422-1 = 0.01 lbs; D4422-3 = 0.01 lbs

86324

RELEASED
2011-07-06

A	NEW ISSUE	MB	11.06.22
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.06.22		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4422	REV. A SHEET 1 OF 1
TITLE SHIM	SCALE NTS
COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

8 7 6 5 4 3 2 1